Work Orde Monday, Decemb				*940	206*				AS	DD		Page 1
Revision ID: Item Name: Start Date: Required Date:		Wall Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*	Accept	*N9C		100	ገ*		tart *	NS NS	S1* S2*
Approvals:		uuF_	Date: \2-2-	1		Date:				tart *	NF NF	२1* २2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Rejec Numl		Insp. Stamp
Draw Nbr	Revisi	on Nbr										
D3876	A											
*100 *100* Waterjet FLOW CNC Waterje		LOW WATER JET  Memo  1-Cut as per  Deburr if ne	r Dwg D3876Dwg Rev:_ ccessary	0.00 0.00 A Prog Rev: A	_2-			3		IBIC	<b>\$_</b> ;	7_
*110 *11 <b>0</b> *	(	QC2- Inspect parts off m	nachine FAI/FAIB	0.00				(3) ····		R	si3-	1-3
QC Quality Control		Memo		0.00				J			-	
120 *120*	Ç	C8- Inspect parts - seco	and check	0.00 (AS)				3	1			
QC Quality Control		Memo		0.00 13-1-	3			ر کیا	-	<del></del>		

2 :

						·					DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPD	ATE			,
									· · · · · · · · · · · · · · · · · · ·		QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	- No					Rework Skid-tube Machining Use-as-is Thermoforming Large Fab			Crosstube Small Fab Finishing Composite	nall Fab Prod. Eng. Coor. nishing Rec/Store/Packaging Supplier			
Root					Descri	ption of work order update		Initial	Acti	on	Sign &		1.0
Cause	$\perp$	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								LT CATE	CORV				
Landi							AUL	LICAIE	GURY				
Landi		Bending Centre No Cracks Crushed/C Cuffs	Crimped,	ntric to	o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination		Instruct Mainte	ion Incomplete tions Incomplete/U enance	nclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	$\vdash$	leat Trea	t			Countersink		Mislabe			Positioned \	Vrong	

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Work Order ID 94906

Monday, December 24, 2012 11:09:18 AM

Item ID: D3876-3

Revision ID:
Item Name: Protector - Fwd Wall

Start Date: 12/24/2012 Start Oty: 3.00

QC:

Required Date: 1/3/2013

Reference:

Approvals:

Sequence ID/

\*130\*
Packaging

Packaging

Work Center ID

\*94906\*

Page 2

\*N900040100\* Setup Start Stop **Cust Item ID: Customer:** Run Start Date: Stop Date: Tool ID Tool # Plan Accept Reject Reject Insp. Code Otv **Qty** Number Stamp

140

130

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

0.00

Accept

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

\*140\*

QC Quality Control

Memo

Memo

Req'd Qty: 3.00

Process Plan:

Operation

Description

0.00

01201-4

												DQA:	Date:	
NCR:	'es	/ No					WORK ORDER NON-C	O	NFORM	/IANCE / UPI	DATE	•		-
												QA Closed:	Date:	
Work Orde	er:						DISPOSITION	ł			AGAINST DI	PARTMENT	PROCESS	4
Part N	No. Work Order						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Des	crip	otion of work order update	1	Initial Action			Sign &		
Cause		Date	Step	Qty		О	r Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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ther											000 1			
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Inapproved					<u> </u>			<u> </u>						<u> </u>
								AUL	T CATE	GORY				
Landi	ng (	1					General	_	1		_	٦	_	I
		Bending				_	Bend	<u> </u>	Grain		-	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	_	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under	-	Temperature/Cure
		Cracks Broken/Damag					•	$\vdash$	1 '	on Incomplete		Part Incorred	<b>⊢</b>	Weld
	Crushed/Crimped. Burrs						-	1	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	<b>├</b> ─┤					Contamination	-	Mainte		<u> </u>	Part Moved			
	<del></del>					Countersink	-	Mislabe		-	Positioned V		Joshan	
	Inspection Strip in Tube Cut Too Short										Other			
	_	Ripples in		_			Drill Holes	$\vdash$	Offset					
		Torque W			n	<u> </u>	Drawing	_	4	Calibration		<del></del>		
		Turning S	equence			l	Finish		Out of S	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Page 1

Work Order ID:

94906

Parent Item:

D3876-3

Parent Item Name:

Protector - Fwd Wall

Start Date: 12/24/2012

121 803

Required Date: 1/3/2013

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	555.0613	3.86	12 190474	4	ط	
GE PLASTICS LEXAN SI	HEET						*-	555.0013	3.00	12.189474	130	5-1-3	

Location Loc Qty Loc Code MAT019 555.0613 121803 555.0613

NCR: Y	es /	No				WORK ORDER NON-O	100	<b>NFORN</b>	ANCE / UPD	<b>DATE</b>			
											QA Closed:	Date	2:
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N NCR N				\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	;	Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root			-1	- 15	Descri	iption of work order update		Initial	Acti	ion	Sign &		100
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				×		LT CATE	CORV						
Landin	na Goo					General	AUI	LICATE	JORT				
Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Jnclear	Ovalized Over/Unde Part Incorre Part Lost/M Part Moved Positioned Power Loss	ect lissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
		oples in	Bend	vtrucio	_	Drill Holes	-	Offset	^alihration				

Out of Sequence
Outside Dimensions

DQA:

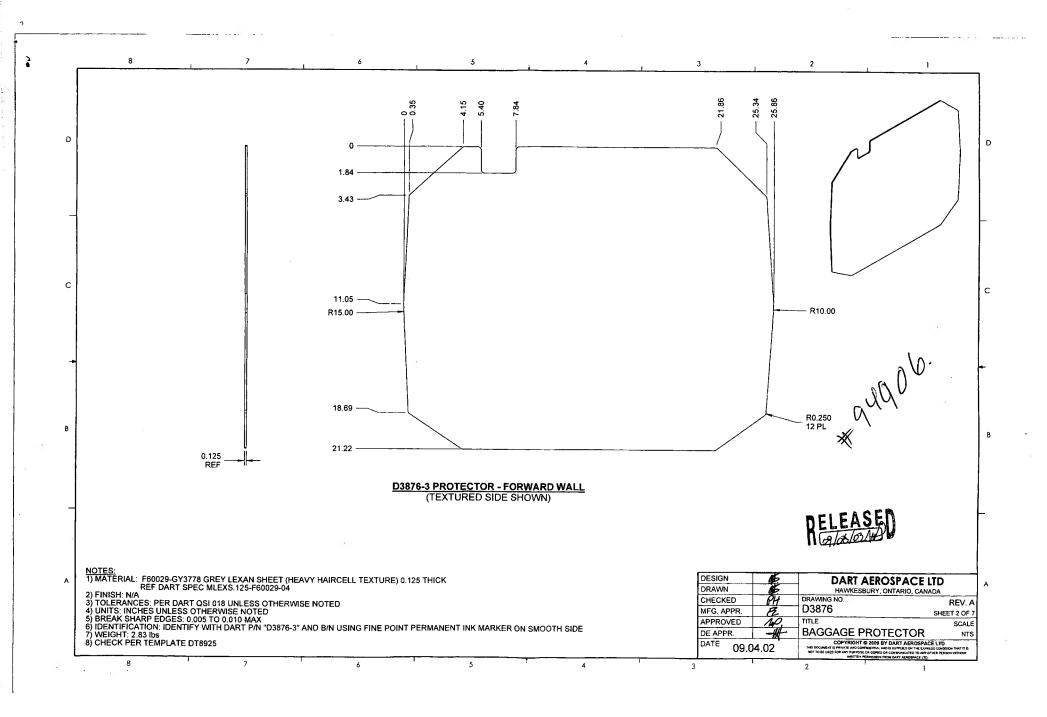
Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed	: Da	ate:	
Work Ord	er.					DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS		
Part I	•			_		Rework Scrap Use-as-is		Machining Small Fab		Crosstube Small Fab Finishing	Water Prod. Eng. Co Rec/Store/Packag			Engineering Quality Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplie	$\overline{}$	
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	on	QC Inspector
Doc/Data												·		
Equip/Tooling														
Operator														
Material														
Setup	Ш													
Other										-				
Process												*		
Supplier														
Training														
Unapproved						<u> </u>	<u> </u>	·						
						F.	AUL	T CATE	GORY					
Landi	ng (	Gear	1			General								
		Bending			L	Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to (	o/s	BOM/Route		Hardwa	ire		Over/Unde	er tolerance		Temperature/Cure
		Cracks				Broken/Damaged	L	Inspect	ion Incomplete		Part Incorr	ect	Ш	Weld
ļ	Ш	Crushed/	Crimped.		L	Burrs		Instruct	tions Incomplete/	'Unclear	Part Lost/N	∕lissing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance	L	Part Move	d <sub>_</sub>		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned	Wrong		•
		Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Los	s/Surge		Other
		Ripples in	n Bend			Drill Holes		Offset						
		Torque W	Vaves in E	xtrusio	ւ 🗀	Drawing		Out of	Calibration					<u>.</u>
}		Turning S	equence			Finish		Out of	Sequence					
		Wave/Tw	ist in Tub	oe .		Folio		Outside	Dimensions					

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DART AEROSPACE LTD	Work Order:	94906
Description: Protector – Fwd Wall	Part Number:	D3876-3
Inspection Dwg: D3876 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.43	+/-0.030	3.43			T 1301	
11.05	+/-0.030	(1,04	0		7	
18.69	+/-0.030	18.69	e		7	
25.86	+/-0.030	≥8.2C	L		7	
25.34	+/-0.030	2534	U		7	(
21.86	+/-0.030	21.86	L		7	
7.84	+/-0.030	784	2		7	
5.40	+/-0.030	5.40			7	1.
4.15	+/-0.030	4:15	_		1	
0.35	+/-0.030	35	C		7	
0.125	+/-0.010	861,	<b>X</b> _	1-	V BUL	
1.84	+/-0.030	1.84	6		1	
						4.5
						4.
			(AS)			

Measured by:	IB.	Audited by:	S 89	Prototype Approval:	N/A
Date:	13-1-3	Date:	13-1-3	Date:	N/A

Rev	Date	Change	Revised	Į į	y	Ap	oro	ved
 Α	09.06.22	New Issue	KJ 9	₹	1	1	1	
				_	<del>,                                    </del>		4	

		÷									DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-C	10:	NFORM	MANCE / UPI	DATE	QA Closed:	Date	
		į	·			DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Work Ord	er: _					DISPOSITION							
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update	Scrap Use-as-is The			Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	П	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		*			-								
,							AUL	T CATE	GORY	· · . · . · . · . · . · . · . · . ·			
Landi		Gear  Bending  Centre Not Concentric to O/S  Cracks  Crushed/Crimped.  Cuffs  Heat Treat  Inspection Strip in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ł	Ripples in Bend				1	לאוחו ווחופי	1	Oliset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish